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June 14th, 2023

Mason Shelly Unipres Corp. Forest, MS

Mason.

The following is a summary of findings from the vibration survey that was performed on June 8th, 2023.

QualiTest® uses a four step rating system for defects.

**CLASS I:** Defect is present, but effect on reliability is not clear; no immediate action is required. Continue to normally monitor.

<u>CLASS II:</u> Defect (s) present that may cause problem in long term (2-6 months). Repair during normal maintenance scheduling. Continue to monitor.

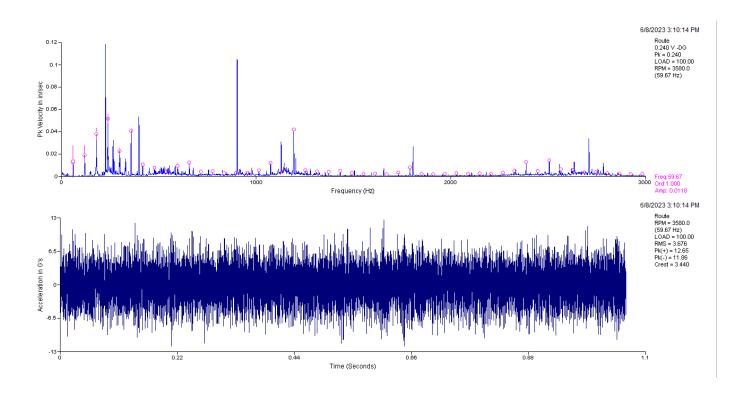
<u>CLASS III</u>; Defect (s) present that may cause failure in short term (less than 2 months). This should be addressed as soon as practical, with a high maintenance priority. Increase monitoring frequency.

**CLASS IV**; Defect (s) present that makes continued reliability unpredictable, and possibility of secondary damage is high. Repairs should be made ASAP. An unscheduled shutdown should be considered for repairs

*Hi-Speed* **Industrial Service** tests and inspects industrial machinery and equipment and makes recommendations concerning maintenance and repairs based on its experience in the field of industrial repair and maintenance. The information contained herein is provided as an opinion only, not as a guaranty or warranty of the matters discussed herein.

# **Defect Summary**

## Air Compressor 1 CLASS II



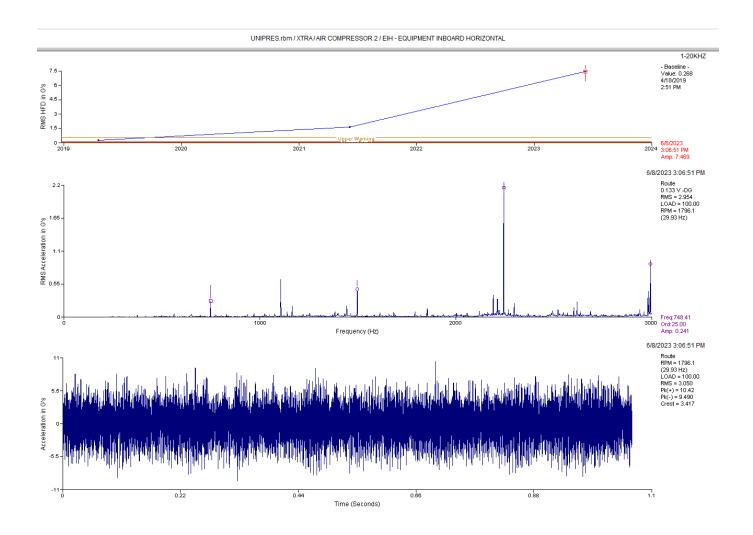
#### **Observation:**

Data above is the input side of compressor. Data shows some peaks that are non-synchronous to shaft speed. This is an indication of possible bearing defects in compressor section.

#### **Recommendation:**

Vibration amplitudes are somewhat lower in motor overall compared to last survey, but compressor section shows elevated acceleration levels. The compressor section likely has defects and wear and needs to be inspected as time allows.

## Air Compressor 2 CLASS II



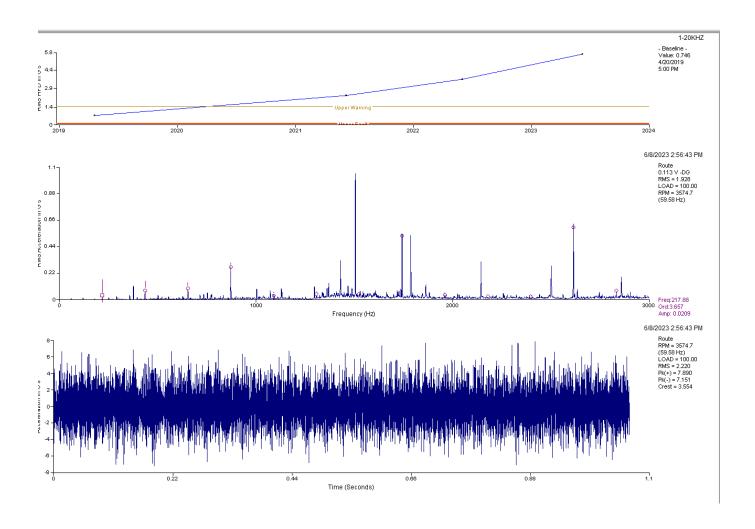
### **Observation:**

Data above is the inboard horizontal compressor. There appears to be several harmonics of 25 x rpm present in the spectral data. This may be a gear issue or other type of internal wear of the compressor section. Trend data shows a significant increase in high frequency amplitude.

#### **Recommendation:**

It is recommended to inspect the compressor section for defects and wear as time allows.

## Air compressor 6 CLASS II



### **Observation:**

Data above is the input side of compressor. Data shows some peaks that are non-synchronous to shaft speed. This is an indication of possible bearing defects in compressor section.

#### **Recommendation:**

Compressor section shows elevated acceleration levels. The compressor section may have defects and wear and needs to be inspected as time allows.

#### 

Database: UNIPRES.rbm Area: UNIPRES

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD
CRANE1MAIN - CRANE 1 MAIN	HOIST (08-	-Jun-23)
	OVERALL LEVEL	1-20KHZ
MOH	.059 In/Sec	.463 G-s
MOV	.056 In/Sec	.230 G-s
MIV	.025 In/Sec	
MIH	.038 In/Sec	
MIA	.032 In/Sec	.060 G-s
GIA	.033 In/Sec	.010 G-s
GIH	.021 In/Sec	
GIV	021 Tn/Sec	013 C-e
G01	.012 In/Sec	.012 G-s
301	.012 111,000	.012 0 5
CRAIN2MAIN - CRANE 2 MAIN		
	OVERALL LEVEL	
МОН	.096 In/Sec	.370 G-s
MOV	.092 In/Sec	.129 G-s
MIV	.040 In/Sec	.055 G-S
MIH	.038 In/Sec	
MIA	.038 In/Sec	.050 G-s
GIA	.020 In/Sec .013 In/Sec	.079 G-s
GIH		
GIV	.064 In/Sec	.106 G-s
G01	.048 In/Sec	.086 G-s
CRAIN3MAIN - CRANE 3 MAIN	HOIST (08-	·.Tun=23)
CIGHTHOLITH CHARL S FAITH	OVERALL LEVEL	
мон	.041 In/Sec	.354 G-s
MOV	.064 In/Sec	306 G-s
MIV	.027 In/Sec	
MIH	035 Tp/God	150 C-c
MIA	.026 In/Sec	.167 G-s
GIA	.033 In/Sec	.107 G-S
GIH	016 Tn/Sec	.034 G-s
GIV	.016 In/Sec .030 In/Sec	.070 G-s
GIV G01	.030 In/Sec	.070 G-S
CRAIN4MAIN - CRANE 4 MAIN		
	OVERALL LEVEL	
MOH	.079 In/Sec	
MOV	.038 In/Sec	.062 G-s
MIV	.032 In/Sec	.062 G-s
MIH	.082 In/Sec	.337 G-s
MIA	.036 In/Sec	.064 G-s
GIA	.036 In/Sec	.064 G-s
GIH	.081 In/Sec	.337 G-s
GIV	.033 In/Sec	.062 G-s
G01	.039 In/Sec	.096 G-s
CRAIN5MAIN - CRANE 5 MAIN	HOIST (08-	-Jun-23)
Orania o Pariti	OVERALL LEVEL	1-20KHZ
MOH	.053 In/Sec	.074 G-s
MOV	.033 In/Sec	.074 G S
MIV	.033 In/Sec	.033 G-s .094 G-s
MIH	.049 In/Sec	.094 G-s
MIA	.029 In/Sec	.168 G-s
MIA GIA	.029 In/Sec	.100 G-S .0041 G-S
	.023 In/Sec	.0041 G-s .0034 G-s
GIH		
GIV	.030 In/Sec	.0043 G-s

G01 .016 In/Sec .049 G-s

CRAIN5AUX	- CRANE	5 AUXULLARY HO	IST	(08-Jun-23)
		OVE	RALL LEVEL	1-20KHZ
мон		. 0	33 In/Sec	.133 G-s
MOV		0	10 In/Soc	.096 G-s
		. 0	49 In/Sec 36 In/Sec	.090 G-S
MIV				
MIH		.0	33 In/Sec	.293 G-s
MIA		.0	29 In/Sec	.367 G-s
GIA		. 0	38 In/Sec	.239 G-s
GIH			26 In/Sec	
_				
GIV		.0	22 In/Sec	.305 G-s
_		_		
CRAIN6MAIN	- CRANE	6 MAIN HOIST		(08-Jun-23)
				1-20KHZ
MOH		.0	55 In/Sec	.206 G-s
MOV		. 0	55 In/Sec 23 In/Sec	.071 G-s
MIV			59 In/Sec	
		. 0	39 III/Sec	.054 G-S
MIH		.0	35 In/Sec	.187 G-s
MIA		. 0	Zo in/sec	.063 G-S
GIA		.0	77 In/Sec	.0041 G-s
GIH		.0	29 In/Sec	.0045 G-s
GIV		0	14 In/Sec	.0039 G-s
G01			14 In/Sec 35 In/Sec	.079 G-s
GUI		.0	35 In/Sec	.079 G-S
			- 0	,,,, = ,,,,,
BKPRDRMTRZ	- BLANK	PRESS FEED UNI		
				1-20KHZ
MOH		.1	29 In/Sec	.027 G-s
MIH		.0	66 In/Sec	.024 G-s
MIA		.0	95 In/Sec	.119 G-s
EA		1	07 In/Sec	
EIH			55 In/Sec	.014 G-s
		. 0	40 Tm/Sec	.014 G-S
EOH		.0	49 In/Sec	.0045 G-s
		UNIPRES.rbm UNIPRES EXTRA		
A	rea:	UNIPRES EXTRA		WED / WHED
	rea:	UNIPRES EXTRA	ALL LEVEL	HFD / VHFD
A	rea:	UNIPRES EXTRA		HFD / VHFD
MEASUREMEN	rea: T POINT	UNIPRES EXTRA OVER	ALL LEVEL	
A	rea: T POINT	UNIPRES EXTRA  OVER   MPRESSOR 1	ALL LEVEL	(08-Jun-23)
AMEASUREMEN AC-1	rea: T POINT  - AIR CO	UNIPRES EXTRA  OVER   MPRESSOR 1  OVE	ALL LEVEL	(08-Jun-23) 1-20KHZ
A MEASUREMEN AC-1 MOH	rea: T POINT  - AIR CO	UNIPRES EXTRA  OVER   MPRESSOR 1  OVE  OVE  1	ALL LEVEL  RALL LEVEL 35 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s
AMEASUREMEN AC-1	rea: T POINT  - AIR CO	UNIPRES EXTRA  OVER   MPRESSOR 1  OVE  OVE  1	ALL LEVEL	(08-Jun-23) 1-20KHZ 1.535 G-s
A MEASUREMEN AC-1 MOH	rea: T POINT  - AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s
AC-1 MOH	rea: T POINT  - AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s
AC-1 MOH MIH MIA	rea: T POINT  - <mark>AIR C</mark> C	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s
A MEASUREMEN AC-1 MOH MIH MIA EA EIH	rea: T POINT  - AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 07 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s
AC-1 MOH MIH MIA	rea: T POINT  - AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s
A MEASUREMEN AC-1 MOH MIH MIA EA EIH	rea: T POINT AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 07 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s
AC-1  MOH MIH MIA EA EIH EOH	rea: T POINT AIR CC	OVER OMPRESSOR 1 OVE .1 .1 .1 .1 .1 .1 .2	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 07 In/Sec 40 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23)
AC-2	rea: T POINT AIR CC	OVER OVER OVER OVER OVER OVER OVE 1 0 1 1 1 1 1 1 1 0 0 0 0 0 0 0 0 0 0	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 07 In/Sec 40 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ
AC-2	rea: T POINT AIR CC	OVER OVER OVER OVER OVER OVER OVE 1 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 07 In/Sec 40 In/Sec RALL LEVEL 72 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH	rea: T POINT AIR CC	OVER OVER OVER OVER OVER OVER OVER OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 41 IEVEL 42 In/Sec 45 In/Sec 46 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA	rea: T POINT AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 72 In/Sec 76 In/Sec 66 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH	rea: T POINT AIR CC	UNIPRES EXTRA  OVER  OMPRESSOR 1  OVE .1 .1 .1 .1 .1 .1 .2 OMPRESSOR 2  OVE .0 .0 .0 .0 .0 .0	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA	rea: T POINT AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec 33 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA EA	rea: T POINT AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s
AC-1  MCH MIH MIA EA EIH AC-2  MOH MIH MIA EA EIH EOH AC-2	rea: T POINT AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec 33 In/Sec 41 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2	rea: T POINT AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec 31 In/Sec 31 In/Sec 31 In/Sec 31 In/Sec 31 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23)
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA EA EIH EOH  AC-3	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 53 In/Sec 40 In/Sec 40 In/Sec 76 In/Sec 66 In/Sec 36 In/Sec 31 In/Sec 31 In/Sec 31 In/Sec 32 In/Sec 33 In/Sec 41 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA EA EIH EOH  AC-3	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-2  MOH MIH MIA EA EIH EOH  AC-3	rea: T POINT AIR CC - AIR CC	OVER  MPRESSOR 1  OVER  OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 42 In/Sec 43 In/Sec 44 In/Sec 45 In/Sec 46 In/Sec 47 In/Sec 48 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s 1.055 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-3  MOH MIH MIA AC-3	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 46 In/Sec 41 In/Sec 46 In/Sec 47 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s 1.055 G-s .553 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-3  MOH MIH MIA EA EIH EOH	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 42 In/Sec 43 In/Sec 44 In/Sec 45 In/Sec 46 In/Sec 47 In/Sec 48 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s 1.055 G-s .553 G-s 2.919 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-3  MOH MIH MIA AC-3	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 46 In/Sec 41 In/Sec 46 In/Sec 47 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec 48 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s 1.055 G-s .553 G-s
AC-1  MOH MIH MIA EA EIH EOH  AC-3  MOH MIH MIA EA EIH EOH	rea: T POINT AIR CC - AIR CC	OVER	RALL LEVEL 35 In/Sec 02 In/Sec 30 In/Sec 30 In/Sec 40 In/Sec 40 In/Sec 40 In/Sec 41 In/Sec 41 In/Sec 41 In/Sec 42 In/Sec 43 In/Sec 44 In/Sec 45 In/Sec 46 In/Sec 47 In/Sec 48 In/Sec	(08-Jun-23) 1-20KHZ 1.535 G-s 1.365 G-s .839 G-s 2.273 G-s 5.580 G-s 7.095 G-s (08-Jun-23) 1-20KHZ .676 G-s 1.872 G-s .827 G-s 3.036 G-s 7.469 G-s 4.219 G-s (08-Jun-23) 1-20KHZ .636 G-s 1.055 G-s .553 G-s 2.919 G-s

AC-5	-	AIR	COMPRESSOR	5	(08-Jun-23)				
					OVERAI	LL LEVEL	1	L-20KI	ΙZ
	MOH				.305	In/Sec		.581	G-s
	MIH				.175	In/Sec		. 936	G-s
	MIA				.074	In/Sec		.360	G-s
	PIA				.141	In/Sec	1	L.401	G-s
	PIH				.234	In/Sec	4	1.996	G-s
	POH				. 285	In/Sec	5	5.389	G-s
AC-6	-	AIR	COMPRESSOR	6			(08-Jı	ın-23)	)
AC-6	-	AIR	COMPRESSOR	6	OVERAI	LL LEVEL	•	ın-23) L-20KI	
AC-6	- мон	AIR	COMPRESSOR	6			` 1	L-20KI	ΙZ
AC-6		AIR	COMPRESSOR	6	.092	LL LEVEL	. 1	L-20KI	IZ G-s
AC-6	мон	AIR	COMPRESSOR	6	.092 .091	LL LEVEL In/Sec	1	L-20KI .763	HZ G-s G-s
AC-6	MOH MIH	AIR	COMPRESSOR	6	.092 .091 .066	L LEVEL In/Sec In/Sec	1	L-20KI .763 L.126 .620	HZ G-s G-s G-s
AC-6	MOH MIH MIA	AIR	COMPRESSOR	6	.092 .091 .066	L LEVEL In/Sec In/Sec In/Sec	` 1 1	L-20KI .763 L.126 .620	HZ G-s G-s G-s <mark>G-s</mark>

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Clarification Of Vibration Units:
Acc --> G-s RMS
Vel --> In/Sec PK

As always, it has been a pleasure to serve Unipres Forest, MS. If there are any comments or questions, do not hesitate to contact us.

Sincerely,

ISO Certified Vibration Analyst, Category III

Kevin W. Maxwell



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